

Please add new claims 20-31.

19. (Amended) A shaped detergent bar produced by the process comprising the steps of:

- 19*
- a. extruding a detergent composition in an extrudable form through a die comprising at least one orifice characterised in that the cross-sectional area for flow through the said at least one orifice is varied continuously during at least part of the time said extrusion is occurring; and
  - b. obtaining an extrudate whose cross-sectional area varies along at least a part of its length.

20. The bar of claim 19, wherein the volumetric flow rate is varied by varying the pumping rate used to deliver the extrudate to the nozzle.

21. The bar of claim 19, wherein the volumetric flow rate is varied by varying the internal volume of a chamber through which the extrudate is delivered to the nozzle.

22. The bar of claim 19, in which the orifice is constructed at least in part from an elastically deformable material.

*23*

23. The bar of claim 19, in which the orifice is constructed of at least two parts which define its cross-sectional area and at least one part can be moved relative to the other so as to vary its cross-sectional area.

24. The bar of claim 23, in which the orifice is of an iris diaphragm construction.

25. The bar of claim 23, in which the orifice is constructed of at least two adjacent cylinders, the cylinders having substantially parallel axes of rotation and being positioned so their circumferential surfaces are in contact, the axes of rotation being substantially normal to the direction of extrusion, the orifice being defined by a

contoured region of the circumferential surface of at least one of the cylinders, the cross sectional area defined by the said contoured region or regions varying with the rotation of the cylinders.

26. The bar of claim 19, in which a primary volumetric flow rate is kept substantially constant during extrusion.

27. The bar of claim 19, in which a secondary volumetric flow rate is varied during extrusion.

28. The bar of claim 19, in which the die comprises more than one orifice whose cross-sectional area for flow is varied during extrusion.

29. The bar of claim 26, in which the cross-sectional areas of the orifices are coordinated such that the sum of the cross-sectional areas remains substantially constant during extrusion.

30. The bar of claim 19, in which the total cross-sectional area for flow through the orifice or orifices and the secondary volumetric flow rate are controlled with respect to each other.

31. The bar of claim 19, in which the temperature of at least part of the die is controlled during the extrusion process.

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**STATUS OF THE CLAIMS:**

Claims 1-19 are now in the case

Claims 1-18 are subject to restriction

Claim 19 is amended

Claims 20-31 are added